

Date: Wednesday, 07/01/2009 12:44:53 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CUFF
Job Number	: 44455		
Estimate Number	: 13023		
P.O. Number	:	Part Number	: D36601
This Issue	: 07/01/2009 S.O. No. :	Drawing Number	: D3660 REVB
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 36835	Material	:
Written By	:	Due Date	: 20/01/2009 Qty: 12 Um: Each
Checked & Approved By	: <u>JLD 09.01.09</u>		
Comment	: est rev A new issue 07.09.19 EC verified by: JLM Est Rev: B 08-04-07 chg to revB DD verified by:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6008180	Crosstube Extrusion
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Comment: Qty.: 0.6384 Each(s)/Unit Total : 7.6608 Each(s) - Loose
 Crosstube extrusion R 70271 SA 09/02/10

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blank 7.300 " long

SA 09/02/10

3.0	DOOSAN LATHE	DOOSAN LATHE
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Comment: DOOSAN LATHE
 1-Turn as per folio FA 708 & DWG D3660,
 FOLIO REV: N/A
 DWG REV: R

2-Deburr as required

SA 09/02/10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 09/02/10

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

JL 09/02/11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JS

09-02-11

RTN

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FS 09/02/11

(12)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST479

AS

09/02/11

(X12)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/13

Job Completion



MF

09-02-12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 44455
Description: CWP		Part Number: 3660-1
Inspection Dwg: 3660 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

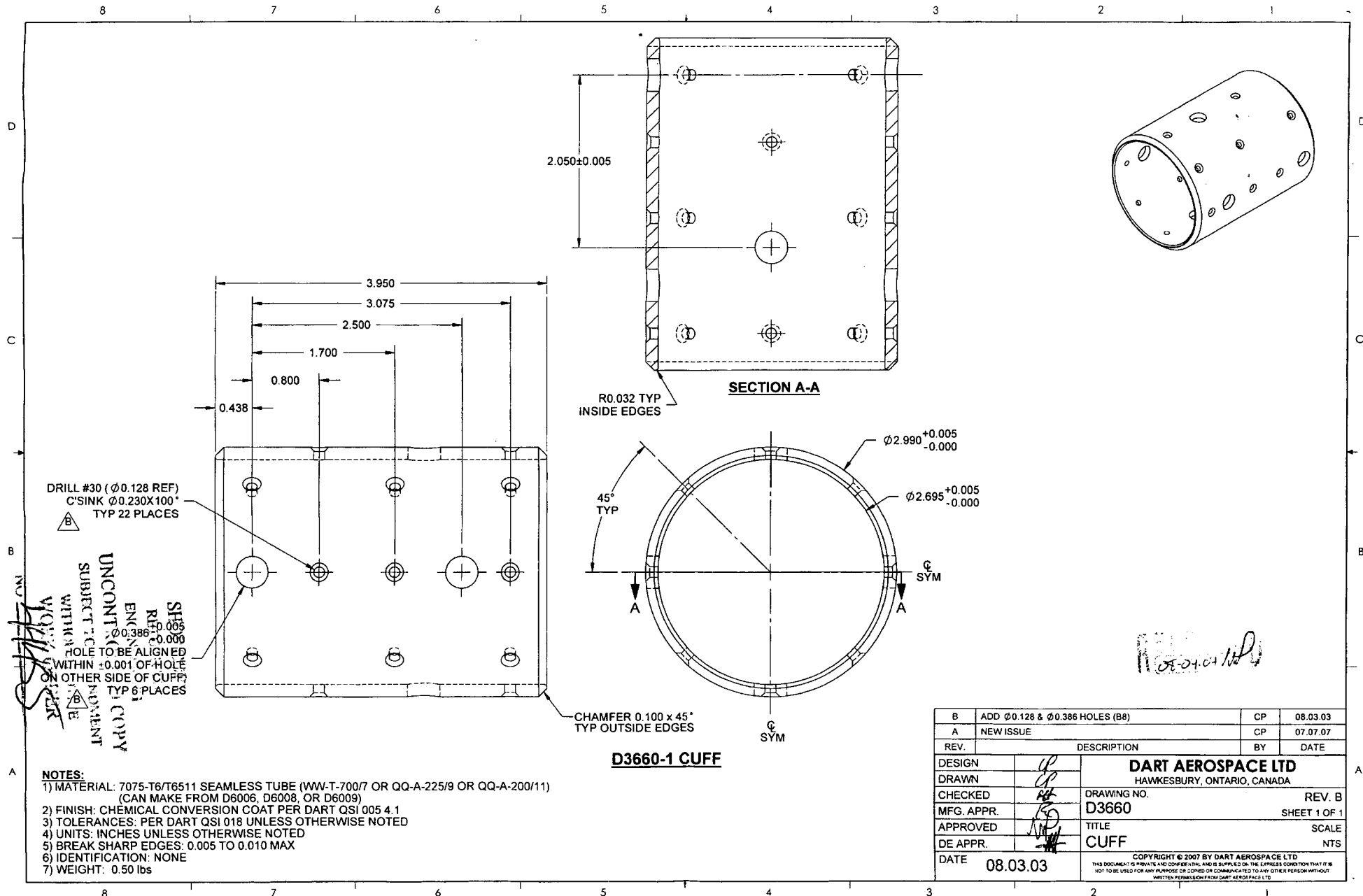
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.950	$\pm .010$	3.952	/			
3.075	$\pm .005$	3.074	/			
2.500	$\pm .003$	2.498	/			
1.700	$\pm .005$	1.698	/			
.800	$\pm .003$.799	/			
.438	$\pm .005$.438	/			
$\emptyset .128$	$\pm .003$	$\emptyset .129$	/			
C-sink $\emptyset .230 \times 100^\circ$	$\pm .010$	$\emptyset .230$	/			
$\emptyset .386$	$\pm .005$	$\emptyset .388$	/			
$\emptyset 2.990$	$\pm .005$	2.984	/			
$\emptyset 2.695$	$\pm .005$	$\emptyset 2.698$	/			
2.050	$\pm .005$	2.050	/			

Measured by: [Signature]	Audited by: J.L	Prototype Approval:	N/A
Date: 09/02/11	Date: 09/02/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

[Signature]



NOTES:

- 1) MATERIAL: 7075-T6/T6511 SEAMLESS TUBE (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11)
(CAN MAKE FROM D6006, D6008, OR D6009)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

0645
194